

86808

July-06-12 2:56:43 PM

N900040100

Setup Start *NS1*

Stop ***NS2***

6

6

Reference:

Run Start *NR1*

Date: 12079

Date:

Stop *NR2*

Date: _____

SPC (Y/N):

Date:

Sequence ID/ Work Center ID	Operation Description	Set/Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3205	Rev B								
100		0.00							
100	BAND SAW								
Bandsaw	Memo	0.00							
Jeaspa Bandsaw	Cut blanks: 3.250" x 2.500" x 4.250" long Bar (+0.030/-0.000)								
110		0.00							
110	HAAS CNC VERTICAL MACHINING #1								
HAAS 1	Memo	0.00							
HAAS CNC vertical machine #1	Machine D3205-1 as per Folio FA346 and Dwg D32051Identify as D3205-1								
	Deburr and Tumble								
120		0.00							
120	QC2- Inspect parts off machine FAI/FAIB								
QC	Memo	0.00							
Quality Control									

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86808

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Item ID: D3205-1 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Pedal Bracket
 Start Date: 7/06/12 Start Qty: 6.00 *6* Cust Item ID:
 Required Date: 8/10/12 Req'd Qty: 6.00 *6* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00							
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3	0.00							
150									
Powdercoat	Memo	0.00							
Powder Coating									

Note: Cover the thread hole for D3205-1 before powder coat. START TIME: 10:50 OVEN TEMPERATURE:

FINISH TIME:

3200 F

11:20

M121279

M.F.
 6X Ø 12/07/26
 M.F.
 6X Ø 12/07/26

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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Work Order ID 86808

July-06-12 2:56:43 PM

86808

Page 3

Item ID: D3205-1

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Pedal Bracket

Start Date: 7/06/12

Start Qty: 6.00

6

Cust Item ID:

Required Date: 8/10/12

Req'd Qty: 6.00

6

Customer:

Reference:

Run Start

NR1

Stop

NR2

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00

160

QC

Memo

0.00

Quality Control

C 6 BR 12-7-26

170

Identify as per dwg & Stock Location: 6A

0.00

170

Packaging

Memo

0.00

Packaging

6x BR 12/17/26

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.00

Quality Control

12/17/30

ML5 12/10/26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

July-06-12 2:56:42 PM

Page 1

Work Order ID: 86808

Parent Item: D3205-1

Parent Item Name: Pedal Bracket

Start Date: 7/06/12

Required Date: 8/10/12

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP A04.06.09New issueKJ/RF

IPP Rev:B 08-12-16 attach DEO DD verified by:EC

IPP REV:C AS PER REV B 12-

03-23 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M7075T73B2.500X03.25 7075-T73 Bar 2.50 x 3.25		Purchased	No			100	f	6.4920	0.3646	2.302737			

Location

Loc Qty

Loc Code

MAT008

6.492

116680

1.572

119916

0.92

121769

4

1.572 ~~3.28~~
.92
36.46

amf 12/07/23

28566

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	<i>82808</i>
Description: Pedal Bracket		Part Number:	D3205-1
Inspection Dwg: D3205 Rev: B		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.100	+/-0.010	1.107	✓		Vern	GA-01
0.250	+/-0.010	0.252	✓		"	"
R0.38	+/-0.030	R0.375	✓		R-6	ref.
0.125	+/-0.010	0.126	✓		Vern	GA-01
0.250	+/-0.010	0.252	✓		"	"
2.380	+/-0.010	2.387	✓		"	"
1.380	+/-0.010	1.380	✓		"	"
0.500	+/-0.010	0.507	✓		"	"
0.880	+/-0.010	0.881	✓		"	"
Ø0.470 x 100°	+0.006/-0.001	Ø0.473 x 100°	✓		"	"
0.440	+/-0.010	0.438	✓		"	"
0.600	+/-0.010	0.597	✓		"	"
1/4-28UNF-313	N/A	1/4-28UNF	✓		1/4-28 bolt	ref.
0.250	+/-0.010	0.255	✓		Vern	GA-01
Ø0.257	+0.006/-0.001	Ø0.257	✓		"	"
1.750	+/-0.010	1.750	✓		"	"
0.870	+/-0.010	0.870	✓		"	"
0.440	+/-0.010	0.439	✓		"	"
R0.25	+/-0.030	R0.250	✓		R-6	ref.
3.000	+/-0.010	3.000	✓		Vern	GA-01
3.96	+/-0.030	3.963	✓		H-6	31006
0.409	+/-0.010	0.409	✓		D-6	GA-08
0.808	+/-0.010	0.809	✓		H-6	31006
2.562	+/-0.010	3.563	✓		"	"

Measured by:	<i>h a</i>	Audited by:	<i>2P</i>	Preliminary Approval:	
Date:	12/07/24	Date:	12-7-25	Date:	

Rev	Date	Change	Revised by	Approved
A	05.02.17	New Issue	KJ/JLM	
B	12.05.14	Dimensions updated per Dwg Rev B	KJ	

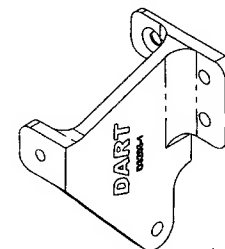
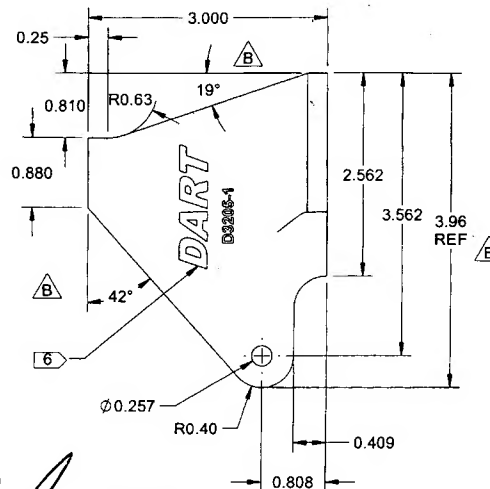
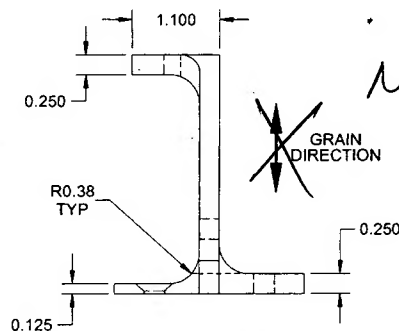
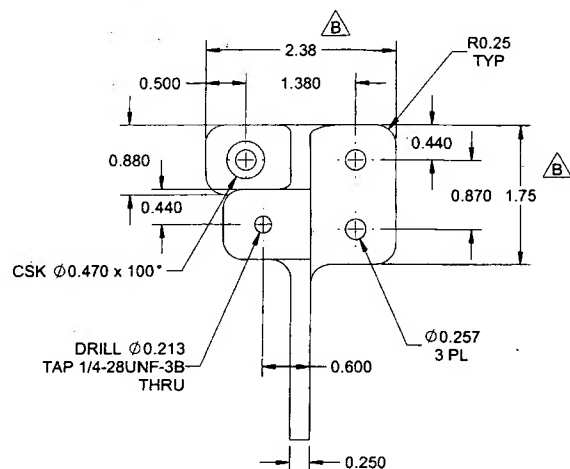
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NOTE: Date & initial all entries



D3205-1 PEDAL BRACKET

NOTES:

- 1) MATERIAL: 7075-T73 ALUMINUM BAR
PER QQ-A-200/11 OR QQ-A-250/12
REF DART SPEC M7075T73B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.3
- 7) WEIGHT: 0.28 lbs

N/A 12-07-25
PAR 12-212
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86808

RELEASED
R 2012-03-21
ECN 12-545 4P

B	CONVERT DRAWING TO STANDARD FORMAT; 3.96 WAS 3.99 (ZN C2-1); 19° WAS 18° (D3-1); 42° WAS 41° (ZN C4-1); CHANGE DIMENSIONS TO 2 DEC. PL (ZN D5-1, D6-1, C4-2, D5-2, C7-2); ADD CHAMFER (ZN D3-2); REMOVE ENGRAVING ON D3205-3	RF	12.02.24
A	NEW ISSUE	RF	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3205 TITLE BRACKET SCALE NTS	
DRAWN	RF		
CHECKED	RF		
MFG. APPR.	RF		
APPROVED	RF		
DE APPR.	RF		
DATE	12.02.24	<small>COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

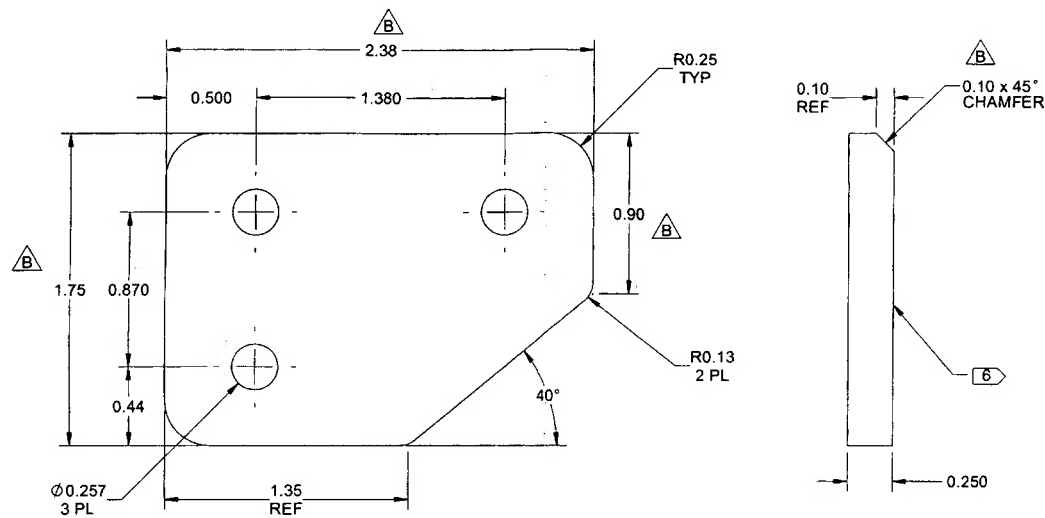
Dart Aerospace Ltd

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3205-3 BACK PLATE

RELEASED
2012-03-21
RCN 12-545 CP

NOTES:

- 1) MATERIAL: 6061-T6/T651/T6510/T6511/T62 ALUMINUM BAR
PER QQ-A-225/8 OR AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
OR QQ-A-200/8 OR AMS-QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.09 lbs

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. B
MFG. APPR.	RF	D3205	SHEET 2 OF 2
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BRACKET	NTS
DATE	12.02.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

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